

Split 2

Work Order ID 87646-1

87646

Page 1

Item ID: D3883-1

Revision ID:

Item Name: Saddle, Outboard LH

Start Date: 7/04/12

Start Qty: 4.00

4

Required Date: 8/17/12

Req'd Qty: 4.00

4

Reference:

Accept

N9000040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Customer:

Approvals:

Process Plan: MLJ

Date: 12/07/24 Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start *NR1*

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3883

C

100

0.00

100

HAAS 1

HAAS CNC vertical machine #1

HAAS CNC VERTICAL MACHINING #1

Memo

Program Batch No. 87646

Double check by: B.A.

1-Machine Step No 1 per Folio FA815 and inspect per attached Dimension Sheets

2-Machine Step No 2 per Folio FA641 and inspect per attached Dimension Sheets

3-Machine Step No 3 per Folio FA815 and inspect per Dimension Sheets

MILL AS PER DWG AND FOLIO FA815

FOLIO REV: AA

DWG REV: C

0.00

B.A. 12/08/02

105

0.00

105

Mill Conv

Conventional Milling Machine

Memo

MILL KEYWAY AS PER DWG

0.00

B.A. 12/08/02

Work Order ID 87646

July-23-12 3:12:48 PM

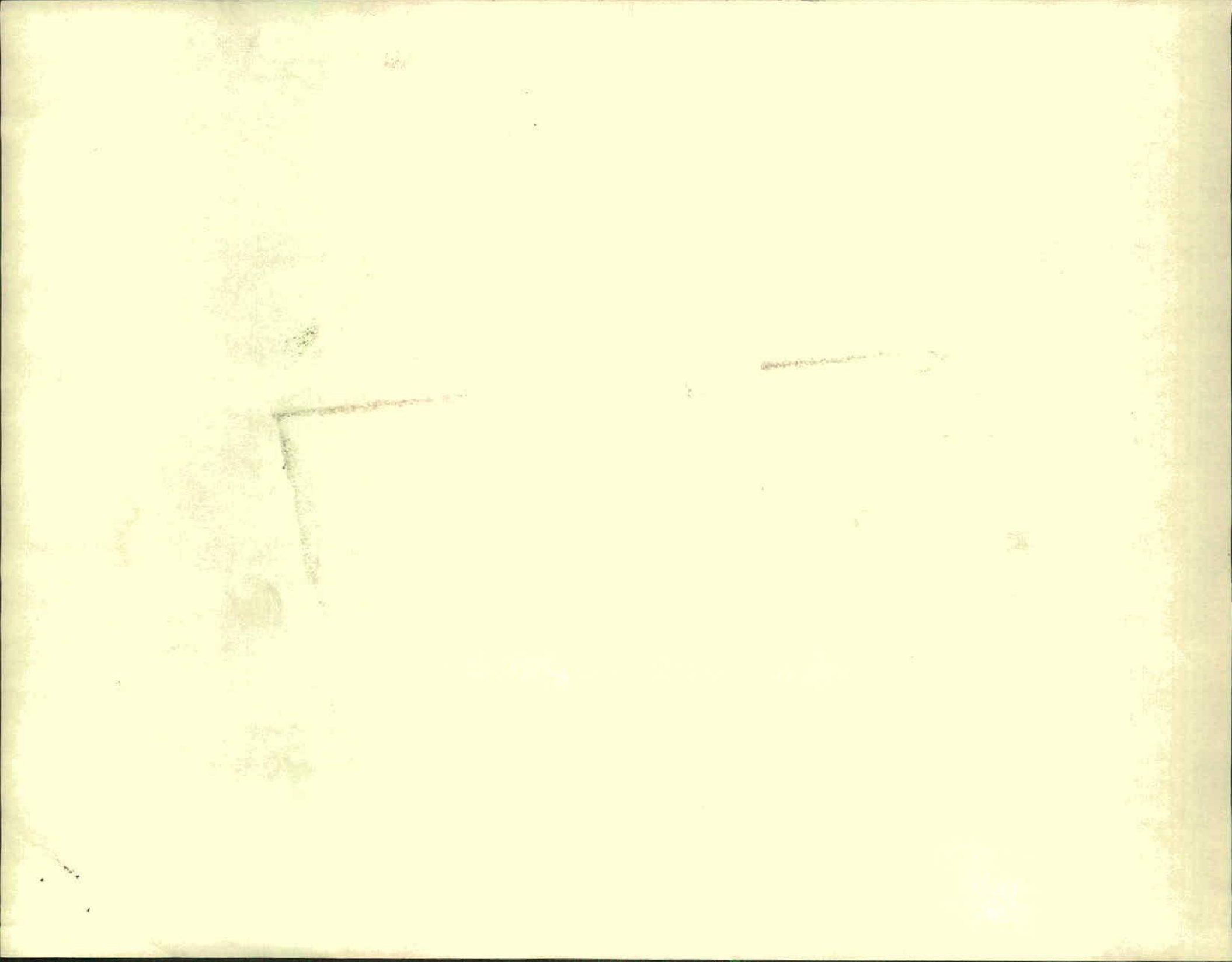
87646

Page 2

Item ID: D3883-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Saddle, Outboard LH
 Start Date: 7/04/12 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 8/17/12 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110 *110* QC Quality Control	QC2- Inspect parts off machine FAI/FAIB Memo	0.00 0.00	B.A	12/08/02					
120 *120* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00	RP SL	12/08/07		4	0		
130 *130* HandFinish Hand Finishing	Chemical Conversion Coat per QS1005 4.1 Memo	0.00 0.00				W	7/3	12-8-8	



July-23-12 3:12:48 PM

Page 3

Packaging

41 2 (2) 12/08/08

4th of November

4X SP
12-8-8

July-23-12 3:12:48 PM

87646

Page-4

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Item Name: Saddle, Outboard LH

Start Date: 7/04/12 Start Qty: 4.00 *4*

Cust Item ID:

Required Date: 8/17/12 Req'd Qty: 4.00 * 1 *

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/
Work Center ID

Operation	Description
1	Start
2	Read input
3	Process input
4	Output result
5	End

Set Up/
Run Hours

Tool ID	Tool #	Plan Code
---------	--------	-----------

Accept
Qty

Reject
QtyReject
NumberInsp.
Stamp

170

QC21- Final Inspection - Work Order Release

0.00

170

QC

Memo

0.00

Quality Control

Qty	Number	Stamp
	12/8/9	77
		me
		12-08-08

Picklist Print

July-23-12 3:12:47 PM

Page 1

Work Order ID: 87646

Parent Item: D3883-1

Start Date: 7/04/12

Required Date: 8/17/12

Parent Item Name: Saddle, Outboard LH

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP RevA: New issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-015 Saddle Billet		Manufactured	No			100	Each	14.0000	1	4		12/08/02	

Location	Loc Qty	Loc Code
MAT047	14	
74800	4	
→ 85568	10	

✓ 4.0

+ 1.0 (some batch)

DART AEROSPACE LTD		Work Order: 87646
Description: Saddle, Outboard, LH		Part Number: D3883-1
Inspection Dwg: D3883	Rev. C	Page 1 of 1

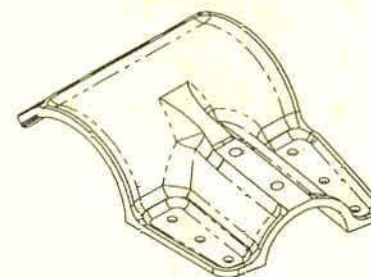
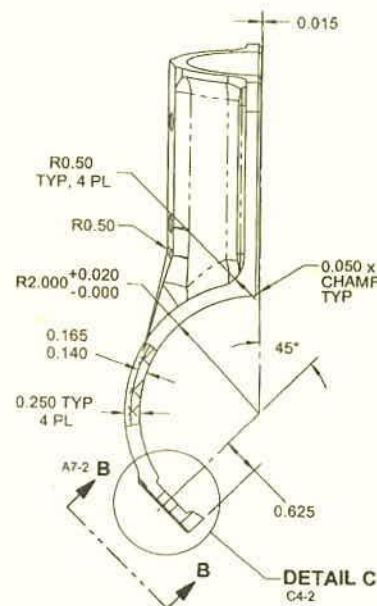
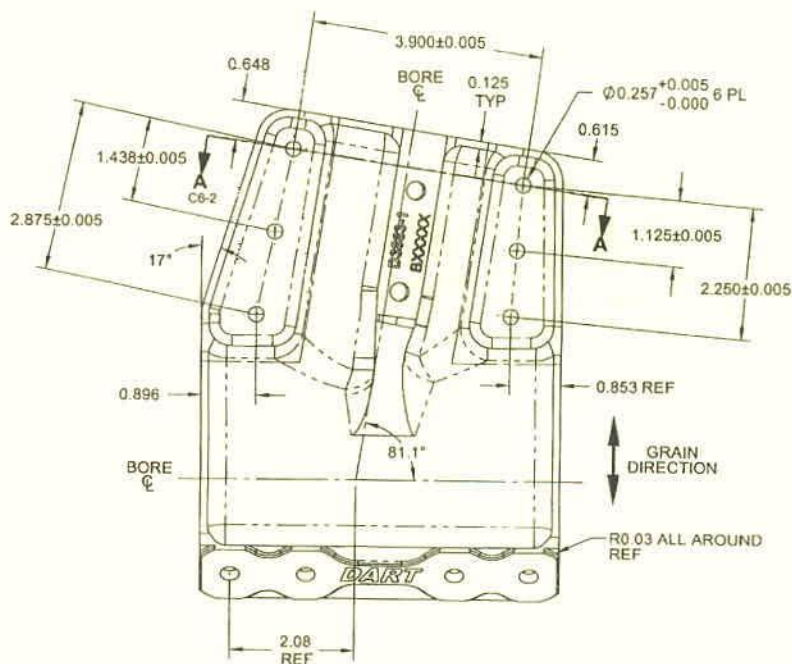
Inspect dimensions highlighted on inspection sheet drawing and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date 5
				1	2	3	4		
A	2.870	2.880		2.875	2.875	2.875	2.875		2.875
B	1.433	1.443		1.438	1.438	1.438	1.438		1.438
C	0.638	0.658		0.645	0.647	0.648	0.648		0.648
D	3.895	3.905		3.900	3.900	3.900	3.900		3.900
E	0.257	0.262		0.258	0.258	0.258	0.258		0.258
F	0.605	0.625		0.615	0.624	0.615	0.615		0.615
G	1.120	1.130		1.125	1.125	1.125	1.125		1.125
H	2.245	2.255		2.250	2.250	2.250	2.250		2.250
I	2.000	2.020		2.005	2.006	2.005	2.005		2.004
J	0.140	0.165		0.135	0.150	0.152	0.151		0.152
K	0.240	0.260		0.237	0.249	0.249	0.249		0.249
L	0.115	0.135		0.120	0.125	0.127	0.127		0.127
M	0.140	0.165		0.135	0.148	0.148	0.148		0.148
N	0.720	0.780		0.750	0.780	0.780	0.780		0.780
O	0.240	0.260		0.250	0.249	0.251	0.251		0.251
P	0.110	0.140		0.140	0.138	0.140	0.140		0.140
Q	0.178	0.198		0.188	0.188	0.188	0.188		0.188
R	2.825	2.885		2.868	2.868	2.870	2.870		2.870
S	0.316	0.321		0.316	0.317	0.316	0.316		0.316
T	0.990	1.010		1.007	1.007	0.996	1.000		1.000
U	1.745	1.755		1.750	1.750	1.750	1.750		1.750
V	5.990	6.010		6.003	6.003	6.003	6.003		6.003
W	1.245	1.255		1.250	1.250	1.250	1.250		1.250
X	0.490	0.510		0.502	0.505	0.507	0.507		0.503
Y	1.220	1.280		1.220	1.240	1.220	1.220		1.220
Z	2.495	2.505		2.500	2.500	2.500	2.500		2.500
AA	0.313	0.318		0.314	0.314	0.314	0.314		0.314
AB	0.020	0.040		0.020	0.028	0.026	0.026		0.020
AC	0.760	0.765		0.760	0.760	0.760	0.760		0.760
AD	0.215	0.220		0.218	0.218	0.218	0.218		0.218
AE	1.265	1.285		1.270	1.271	1.270	1.270		1.269
AF									
Accept/Reject									

Measured by: <u>SL</u> / <u>h.m</u>
Date: <u>12/08/01</u> / <u>12/08/02</u>

Audited by: <u>RF/SL</u>
Date: <u>12/08/02</u>

Rev	Date	Change	Revised by	Approved
A	09.10.22	New Issue	KJ	JLM
B	09.11.25	Dimension AE added	KJ	<u>[Signature]</u>



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RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

801 87646 MLO
12/07/24

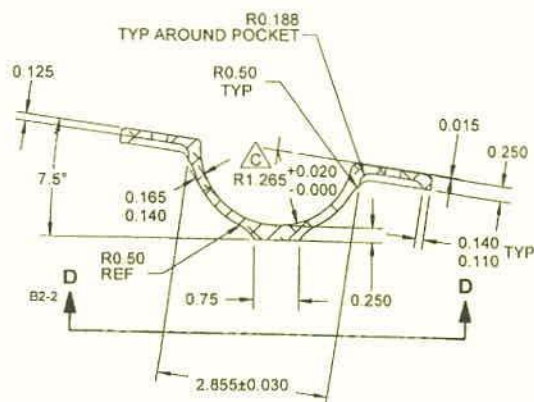
RELEASED
2009-11-19
MP

D3883-1 SADDLE, OUTBOARD LH (SHOWN)
D3883-2 SADDLE, OUTBOARD RH (OPPOSITE)

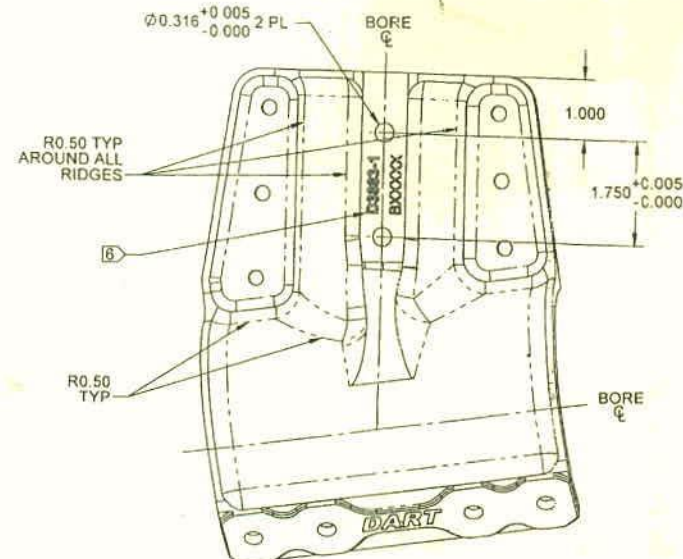
NOTES:

- 1) MATERIAL: 7075-T7351 ALUMINUM PER AMS-QQ-A-250/12, OR QQ-A-250/12 OR ASTM B209 (REF DART SPEC. D6101-015)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX. DEPTH OF 0.010 WITH A MIN. TOOL RAD OF R0.010
- 7) WEIGHT: 1.00 lbs
- 8) ENGRAVE DART LOGO TO MAX DEPTH OF 0.015 WITH MIN RAD 0.250

C	ADD R1.265 (ZN D6-2)	RF	09.11.09
B	D6101-015 WAS D6102-015. ZN A7-1; ADD 0.648. ZN D7-1; ADD 0.615. ZN D6-1; ADD 0.125. ZN D7-2; ADD 0.050 & R0.031. ZN B5-2; 0.75 WAS 0.72R. ZN C7-2	RF	09.15.30
A	NEW ISSUE	RF	09.05.30
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE USA, INC. PORTHADLOCK, WA	
DRAWN	RF		
CHECKED	RF	DRAWING NO.	REV. C
MFG. APPR.	RF	D3883	SHEET 1 OF 2
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	OUTBOARD SADDLE	NTS
DATE	09.11.09	COPYRIGHT © 2009 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR TRANSMITTED TO ANY OTHER PERSON OR ENTITY WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE USA, INC.	

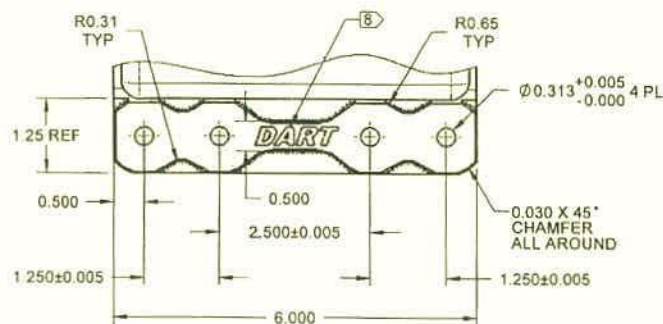


SECTION A-A C7-1

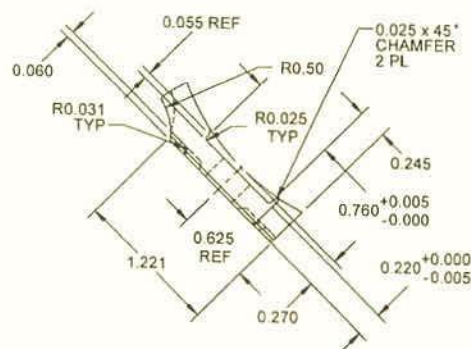


VIEW D-D C7-2

27646



VIEW B-B B4-1
(ROTATED FOR CLARITY)



DETAIL C B3-1
SCALE 2X

RELEASED
2009-11-19
MP

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	PORT HADLOCK, WA	
CHECKED	RF	CRAWING NO.	REV. C
MFG. APPR.	RF	D3883	SHEET 2-OF 2
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	OUTBOARD SADDLE	MTS
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